Work Order ID 53661

November 11, 2009 3:31:14 PM

Item ID: D3827-041 **Accept** **Setup Start** **Stop**

Revision ID: A

Item Name: Rib Assembly (Inboard)

Start Date: 11/11/2009 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 18/11/2009 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** [signature] **Date:** 09/11/12 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3827	Rev A								
100		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							

(6) SP 09.11.18

1- cut D3827-1 rib as per dwg D3827 SAD 09-11-17

2- drill holes using DT9435 jig and open to finish size as per dwg D3827 SAD 09-11-17

3- c'sink as per dwg SAD 09-11-17

4- remove identification markings SAD 09-11-17

5- deburr SAD 09-11-17

6- weld bushing in rib as per dwg D3827
A/R S.S. Rod Batch: ~~108775~~ SP 09.11.18

7- grind weld flush SP 09.11.18

8- deburr if necessary SP 09.11.18

Work Order ID 53661

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Start Date: 11/11/2009 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 18/11/2009 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC10- Inspect visual per QSI004- ground welds	0.00				6	09	11	18
QC	**Memo**	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00				(6)	0		
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: WA	0.00				(6)			
Packaging	**Memo**	0.00							
Packaging									

SAD 09-11-19

Work Order ID 53661

November 11, 2009 3:31:14 PM

Item ID: D3827-041
Revision ID: A
Item Name: Rib Assembly (Inboard)
Start Date: 11/11/2009 **Start Qty:** 6.00
Required Date: 18/11/2009 **Req'd Qty:** 6.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

09/11/26 AJ

BS 09-11-20

Picklist Print

November 11, 2009 3:31:18 PM

Work Order ID: 53661

Parent Item: D3827-041RevA

Parent Item Name: Rib Assembly (Inboard)

Start Date: 11/11/2009 **Required Date:** 18/11/2009

Comments: IPP RevA: revise process 0.9.11.11 DD verified by:EC

Start Qty: 6.00 **Required Qty:** 6.00

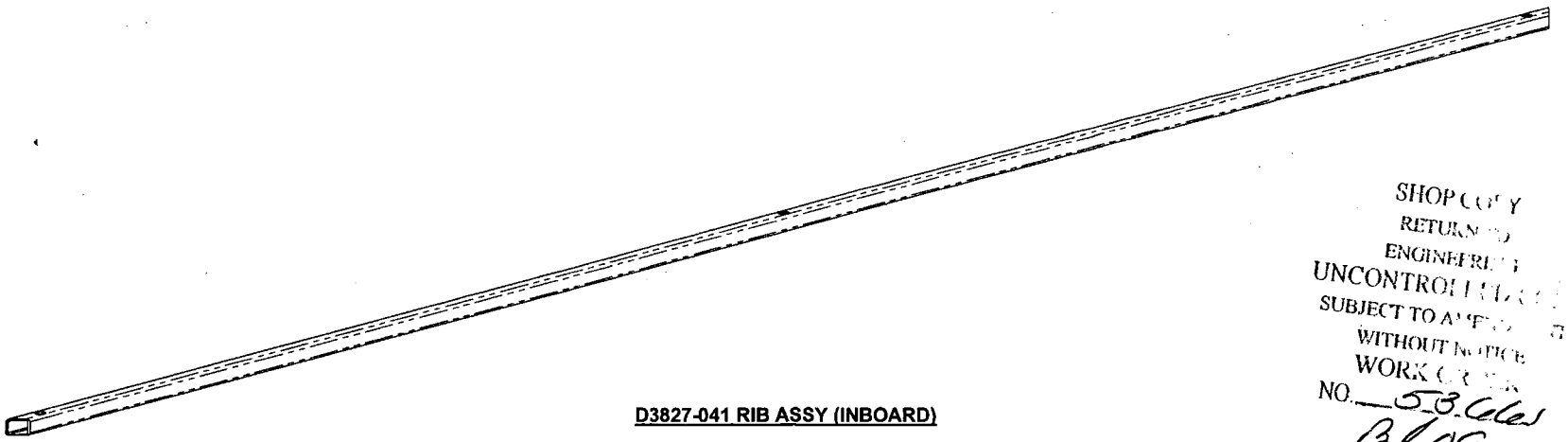
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA		Manufactured	No			100	Each	66.0000	18.0000			
Bushing										SAD	09.11.18.	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
WA	66		
51473	30		15 x 2 ✓
53442	36		30.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	479.3370	50.5263			
304 SQ Tube .75x.75x.065W										SAD	09-11-17	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	473.6842		
113082	473.6842		50.5263 ✓
Main Warehouse			
WA	5.6527947		
112398	5.6527947		

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



D3827-041 RIB ASSY (INBOARD)

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53.666
BJ 09-11-12

RELEASED
08/11/23

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.59 lbs

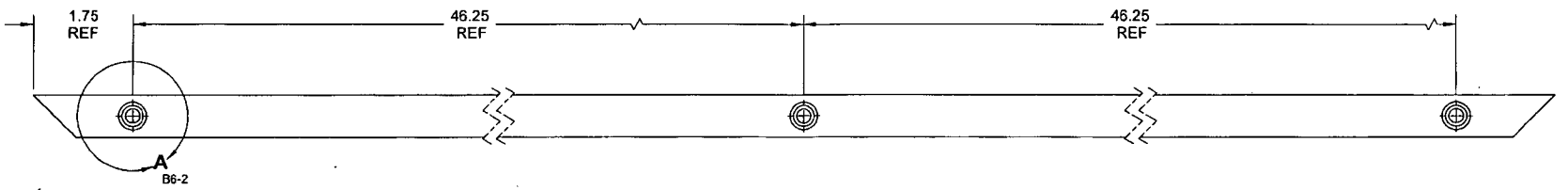
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.09.23

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.09.23

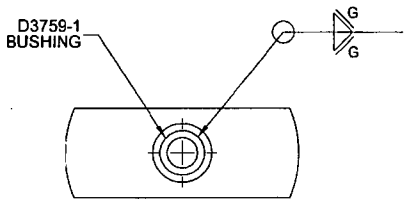
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3827 REV. A
SHEET 1 OF 3
TITLE RIB ASSY (INBOARD) SCALE NTS

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D3827-041 RIB ASSY (INBOARD)



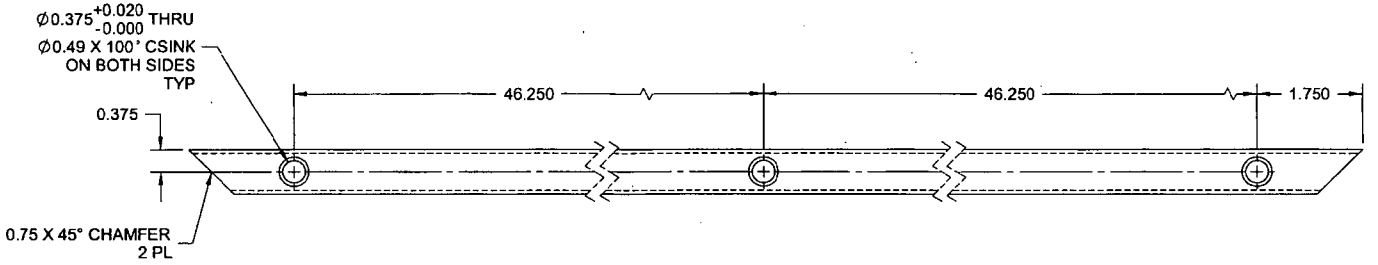
DETAIL A C7-2
SCALE 2X
3 PL

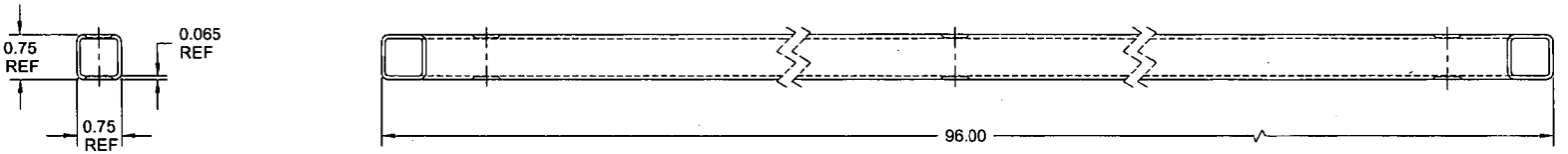
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08/11/18 MJ

w/o 53066

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MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE: RIB ASSY (INBOARD) — SCALE: NTS
DE APPR.		
DATE 08.09.23		

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D3827-1 RIB

RELEASED
08/10/23

W/O 53661

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.55 lbs

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CHECKED		DRAWING NO. D3827 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE RIB ASSY (INBOARD) SCALE NTS
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